

5/30

DART AEROSPACE LTD	Work Order:	23713
Description: Wearplate	Part Number:	D3319-1
Dwg: D3319 Rev. A page 1	Qty:	10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		05.06.30	10
2	PG	Issue P/O: <u>1008305</u> <b>Email or Ship DXF file to vendor</b> Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser <b>Material release note is required</b>		05.06.30	10
3	RG	Receive and inspect for transit damage <b>Ensure material release note is attached</b>	DL	05/07/28	10
4	QC6	Inspect dimensions as per inspection template D3319-1T1			
5	GA	Deburr if necessary			
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev: _____			
7	GB	Form flat on press using DT8776 block Dwg Rev: _____			
8	QC6	Inspect dimensions as per Dwg D3319			
9	WS	Weld hard surface using D3319-1T2 as per QSI 004 and Dwg D3319 Dwg Rev: _____ Qty Part Number Description Batch A/R N/A 7560 Hardcoat Rod			
10	QC9	Inspect weld			
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 0054.3			
12	QC3	Inspect Powder Coat			
13	ST	Identify on inside surface using a permanent fine point marker with the following: <b>TCCA-PDA, Dart Aerospace Ltd.</b> <b>P/N: D3319-1, B/N: BXXXXX</b> <b>For Product Eligibility see PDA04-18 and Stock</b>			
14	AC	Cost / part: <u>71.50</u>	SUE	05-10-26	
15	DC	Close W/O Inspect Level 21			

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

# PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-19	4	Parts are no longer good. due to design change, <del>part</del>		SCRAP; destroy. No use for engineering	05-10-19	05-10-19		05-10-19

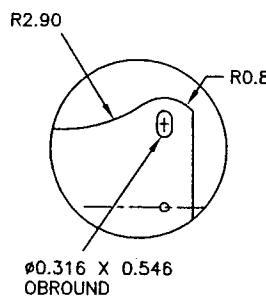
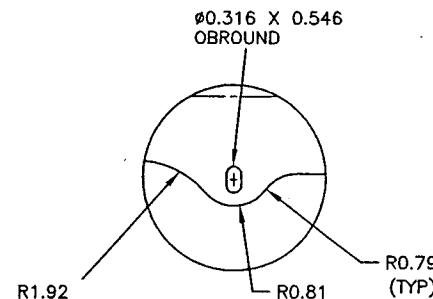
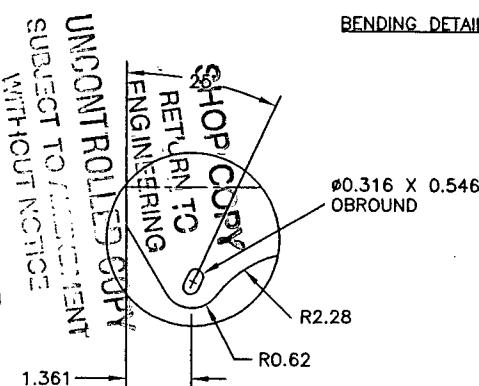
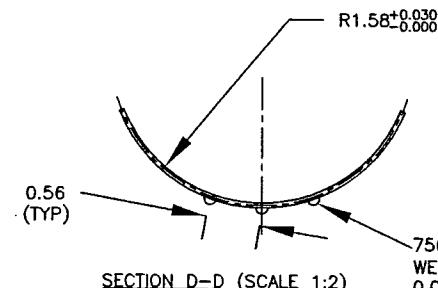
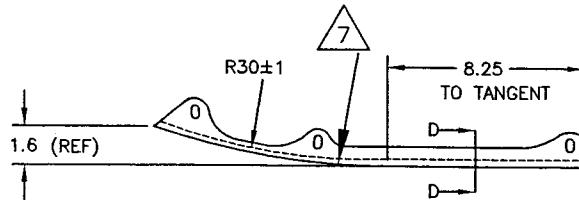
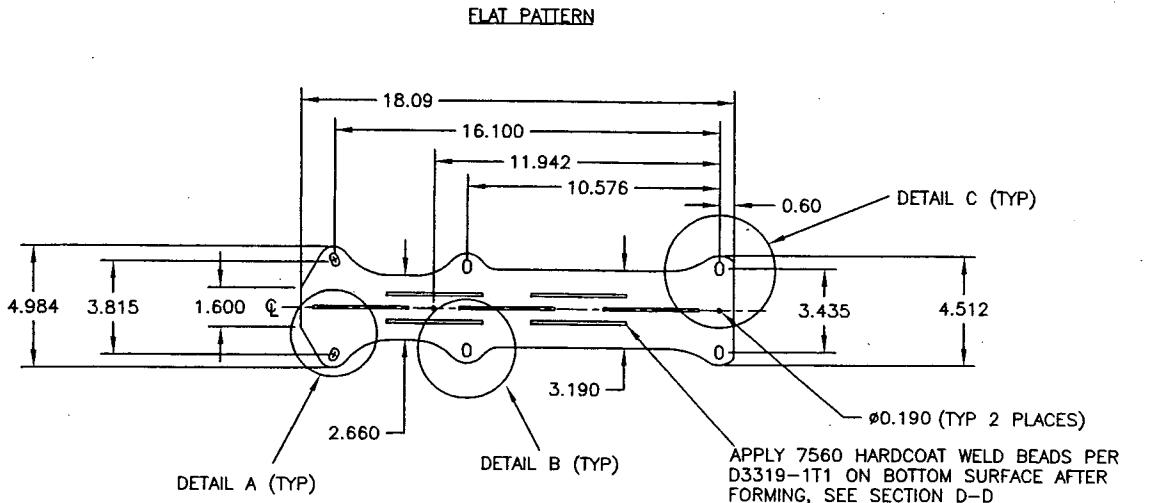
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**DART**

**RELEASED**  
05-04-29



**DETAIL C (SCALE 1:4)**

**D3319-1 WEARPLATE**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:  
 "TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA04-XX"

DESIGN <i>Pf</i>	DRAWN BY <i>Pf</i>	DART AEROSPACE LTD	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3319	REV. A
DATE 04.09.24		TITLE WEARPLATE	SHEET 1 OF 5
A	04.09.24	NEW ISSUE	SCALE 1:8

## Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Jun 30, 2005  
02:06 pm

Work Order No : 0023713  
 Project Name : D3319-1  
 Project For : WK530  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3319-1  
 Description : Wearplate  
 Manufactured : Yes  
 Amount Req'd : 10  
 Amount Done : 0  
 Start Date : 06-30-05  
 Est Finish Date : 07-30-05  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:  
 Burden Flags : NNNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00

Order Entry No :  
 OE Value : 0.00

Est Mark Up : 0.000%  
 Actual Mark Up : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss)	0.00	0.00



New Zealand Steel Limited  
Glenbrook, South Auckland  
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Telephones: (09) 375 8999 / 375 8111 Auckland  
(09) 235 8069 / 235 8535 Waikato  
Fax: (09) 375 8959

## TEST CERTIFICATE

Ref. 5005/21329

CUSTOMER	Wilkinson	P41007D1002												SPECIFICATION	ASTM A106 CS Type A						CERTIFICATE NO	TC107796		
CUSTOMER O/N	90-21N-288													PRODUCT	CRA WIDE COIL						PAGE	1 of 1		
MILL O/N	453665													DIMENSIONS	8.033" x 48" x Coil						DATE	31 March 2005		
PACK NUMBER	HEAT No	C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE( )	MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)						
		x100													x1000	x10000	x100	BEND 180°	YIELD	T.S.	%ELONG G.L=	HARDNESS HRB	r ( )	LENGTH (feet)
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good			41		2621	
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good			41		2723	
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good			50		2546	
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good			50		2789	

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 So (F)=0"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+S/24 (D)=
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WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED *Satish Misra*  
QC METALLURGIST

20 GA CRM<sub>5</sub>